

Date: Tuesday, 23/09/2008 9:11:05 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT WEB
Job Number : 42213	
Estimate Number : 10791	
P.O. Number :	Part Number : D3282041
This Issue : 23/09/2008 S.O. No. :	Drawing Number : D3282 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : C
Previous Run : 39770	Material :
Written By :	Due Date : 30/09/2008 Qty: 4 Um: Each
Checked & Approved By : <u>W 08.9.23</u>	
Comment : Est Rev:B 05.09.23 Procedure change KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2792130	EXTRUSION
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Comment: Qty.: 1 Each(s)/Unit Total: 3 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2792-130

Extrusion

~~B33518~~ B33518

Identify as D3282-1

RT 08-09-23

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3282.

2- inspect for surface damage as per QSI0018

RT 08-09-23

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

ML 08/09/29

4

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 08/09/29

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 9:11:05 AM
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Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8.5 08/09/30

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

25 08-09-30

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

⑧ 11-9-30

8.0 D32831 Doubler



Comment: Qty.: 2 Each(s)/Unit Total: 6 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

139163

⑧

11-9-30

9.0 MS20470AD47 Rivet, Universal Head



Comment: Qty.: 57 Each(s)/Unit Total: 171 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

1107242

(228)

11-9-30

10.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 1107674

④

11-9-30

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

500/09/30

⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FLOAT WEB

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Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG.

M 8-9-30

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42213
Description: Float Web		Part Number: D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.6	✓			
1.500	+/-0.010	1.500	✓			
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	6.000	✓			
1.250	+/-0.010	1.250	✓			
30.000	+/-0.010	30.000	✓			
1.500	+/-0.010	1.500	✓			
72.01	+/-0.030	72.010	✓			
61.75	+/-0.030	61.750	✓			
57.50	+/-0.030	57.500	✓			
49.19	+/-0.030	49.190	✓			
43.94	+/-0.030	43.940	✓			
39.69	+/-0.030	39.690	✓			
26.68	+/-0.030	26.680	✓			
0.55	+/-0.030	.550	✓			
1.970	+/-0.010	1.970	✓			
2.38	+/-0.030	2.375	✓			
0.05	+/-0.030	.052	✓			

Measured by: <i>gm</i>	Audited by: <i>LS</i>	Prototype Approval:	N/A
Date: 08/09/29	Date: 08/09/30	Date:	N/A
Rev	Date	Change	Revised by
A	07.04.02	New Issue	KJ/JLM <i>AK</i>
			Approved <i>AK</i>

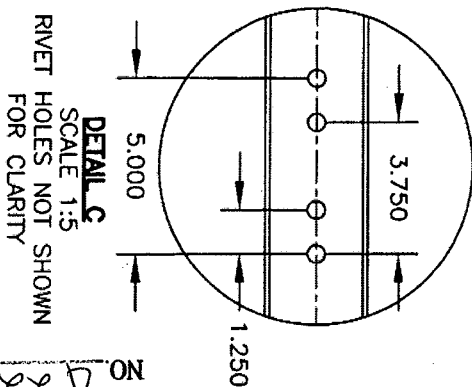
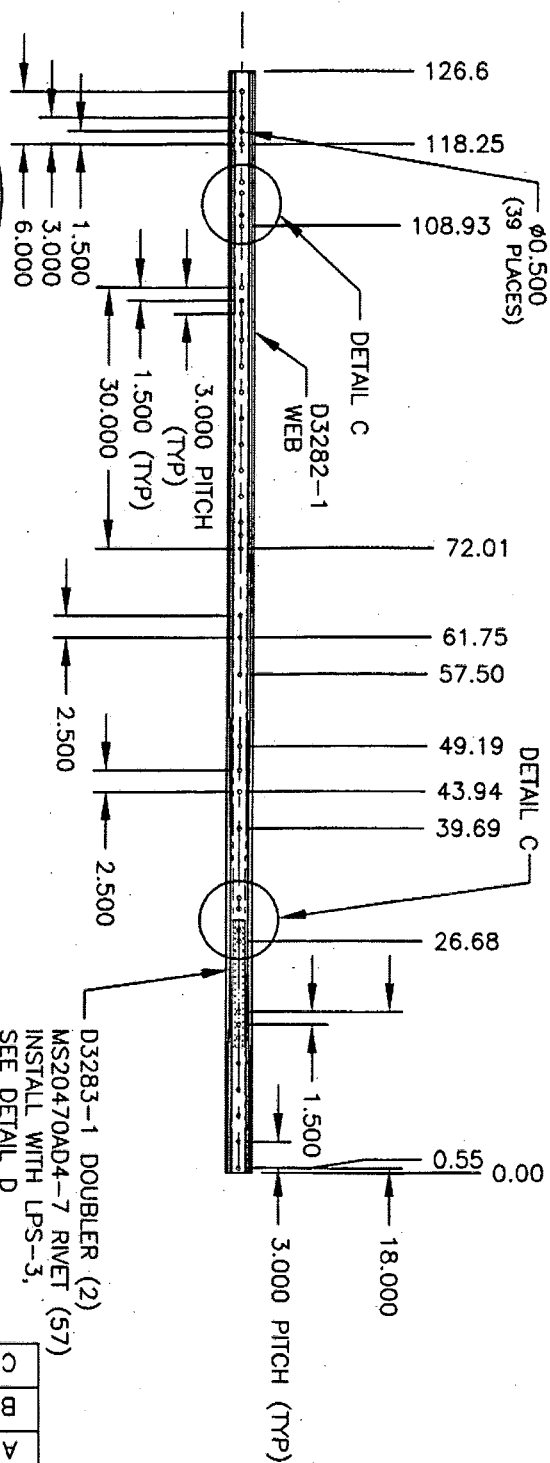
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

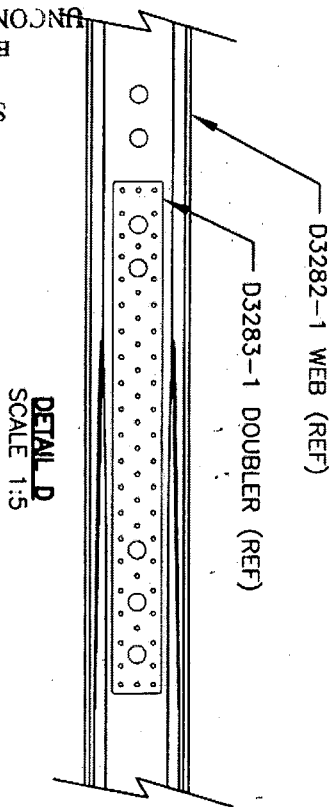
NOTE: Date & initial all entries



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION ¹⁵
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS



D3283-1 DOUBLER (2)
MS20470AD4-7 RIVET (57)
INSTALL WITH LPS-3,
SEE DETAIL D

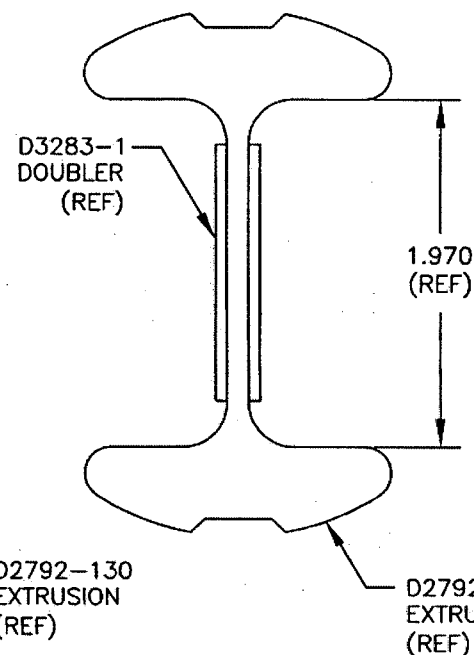
RELEASED

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	PORT HADLOCK, WA
CHECKED		APPROVED		DRAWING NO.	D3282
				REV. C	SHEET 1 OF 2
DATE	05.08.09				
TITLE	FLOAT WEB, 206L/407				
	SCALE				
	1:20				
A	04.05.05		NEW ISSUE		
B	05.03.16		MOVE HOLES, ADD D3390-1 DOUBLERS		
C	05.08.09		REMOVE D3390-1, NOW MACHINED		

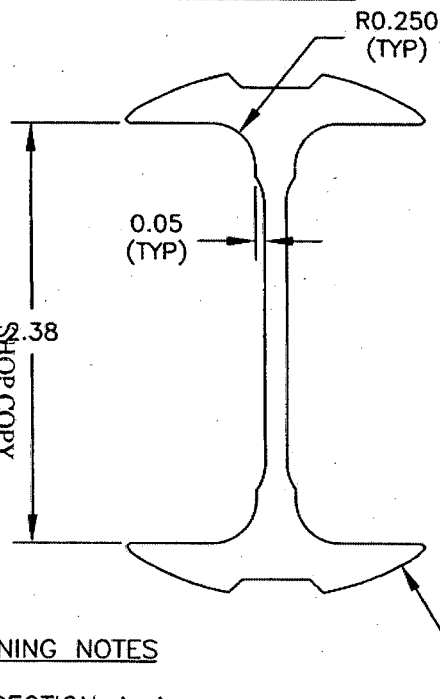


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		TITLE	FLOAT WEB, 206L/407	SHEET 2 OF 2
		SCALE	1:20	

SECTION B-B



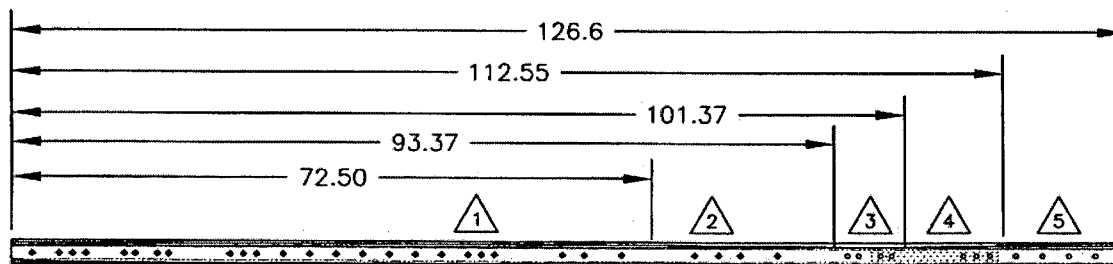
SECTION A-A



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 9225

D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
05.09.12